



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D5957
Job Sheet 179526



Part No: D5957

Part Name: Saddle

Job Qty: 6 ea **570**



Part Weight: 0 lbs

Job Created: 6/20/18

Due Date: 7/24/18

Type: SOLD

Status: Scheduled

Priority: Medium

Job Tracking No:

Created By: Linda Lacelle

Description:

Note: DWG REV B IPP Rev:E Re-Format 05-11-29 JLM IPP Rev:F ecn826 06.12.06 ec

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	6 Ea		7/24/18	0.00	0.00	Start Up Machining-4		SBZ 18/07/12
100	CNC Vertical Machining	6 pcs		7/24/18	3.66	16.22	HAAS1-5		SBZ 18/07/12
110	QC	6 pcs		7/24/18	0.00	0.00	QC1		SBZ 18/07/12
120	QC	6 pcs		7/24/18	0.00	0.00	QC8 Machining-4		SBZ 18/07/12
130	HandFinish	6 pcs		7/24/18	0.00	0.36	HandFinish1 SA 18-07-20		18/07/14
140	Powdercoat	6 pcs		7/24/18	0.00	0.29	Powdercoat1		18-07-23
150	QC	6 pcs		7/24/18	0.00	0.00	QC3		18-07-23
160	Packaging	6 pcs		7/24/18	0.00	0.00	Packaging3-2		18-07-23
170	QC21-SA	6 Ea		7/24/18	0.00	0.00	QC21		18-07-23

Part Op 100 - 1-Machine as per folio D5957, Ensure Batch Number is entered

Descriptions: 110 - Inspect on CMM as per folio CMM046

140 - START TIME: **2:15 01.17.300° FINISH: 2:45.11 08839**

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D6101-007	Saddle Billet	6 Ea (1 ea)	90-Start up Operation	5069074 + 5077236

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D6101-007	6	45	0

Part Specifications

Specifications could not be found.

Plex 6/20/18 8:08 AM dart.lacelle.linda

DART AEROSPACE LTD		Work Order: 179526
Description: Inner Aft Saddle		Part Number: D5957
Inspection Dwg: D5957	Rev: B	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.438	0.443		438	438	438	438		
B	1.745	1.755		1,750	1,750	1,750	1,750		
C	5.245	5.255		5,250	5,250	5,250	5,250		
D	6.995	7.005		7,000	7,000	7,000	7,000		
E	5.240	5.260		5,250	5,250	5,250	5,250		
F	4.745	4.755		4,750	4,750	4,750	4,750		
G	0.315	0.322		316	316	316	316		
H	1.522	1.532		1,527	1,527	1,527	1,527		
I	3.048	3.058		3,053	3,053	3,053	3,053		
J	4.575	4.585		4,580	4,580	4,580	4,580		
K	0.315	0.322		316	316	316	316		
L	0.495	0.505		500	500	500	500		
M	0.490	0.510		498	498	500	498		
N	1.865	1.885		1,875	1,875	1,875	1,875		
O	7.990	8.010		7,999	7,999	7,999	7,999		
P	2.240	2.260		2,250	2,250	2,250	2,250		
Q	0.308	0.313		312	311	311	311		
R	0.760	0.765		760	760	760	760		
S	0.490	0.510		500	498	498	498		
T	1.625	1.645		1,625	1,625	1,625	1,625		
U	2.000	2.020		2,000	2,000	2,000	2,000		
V	0.023	0.043							
W									
X									
Y									
Z									
AA									
AB									
AC									
AD									
AE									
AF									
Accept/Reject									

Measured by: DAS	Audited by: <i>[Signature]</i>
Date: 57 18/07/12	Date: 18/07/14

Rev	Date	Change	Revised by	Approved
A	99.04.19	New Issue	RF	
B	02.12.13	Reformat; Added Dim. T-U & DT8682, DT8686 & DT8696 A/B	KJ/RF	
C	06.11.20	Added dimension V	KJ/JLM	
D	06.12.06	Dimensions L,N,P revised	KJ/EC	
E	07.06.15	Dimension G revised	KJ/JLM	
F	08.04.21	Dimension E revised	KJ/DD	
G	08.09.05	Dimension K revised	KJ/DD	
H	09.07.29	Dimension Q revised	KJ	<i>[Signature]</i>

DART AEROSPACE LTD		Work Order: 179526
Description: Inner Aft Saddle		Part Number: D5957
Inspection Dwg: D5957	Rev: B	Page 1 of 1

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				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	15	26	17	18		
A	0.438	0.443		438					
B	1.745	1.755		1750					
C	5.245	5.255		5250					
D	6.995	7.005		7000					
E	5.240	5.260		5250					
F	4.745	4.755		4750					
G	0.315	0.322		310					
H	1.522	1.532		1527					
I	3.048	3.058		3053					
J	4.575	4.585		4580					
K	0.315	0.322		310					
L	0.495	0.505		500					
M	0.490	0.510		499					
N	1.865	1.885		1875					
O	7.990	8.010		8000					
P	2.240	2.260		2250					
Q	0.308	0.313		311					
R	0.760	0.765		760					
S	0.490	0.510		499					
T	1.625	1.645		1625					
U	2.000	2.020		2000					
V	0.023	0.043							
W									
X									
Y									
Z									
AA									
AB									
AC									
AD									
AE									
AF									
Accept/Reject									

Measured by:		Audited by: [Signature]	
Date:		Date: 18/07/14	

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G	08.09.05	Dimension K revised	KJ/DD	
H	09.07.29	Dimension Q revised	KJ	[Signature]

1961-1962

Date: 18/07/12

QA Closed:  Date: JUN 19 2019

WORK UNDER NON-CONFORMANCE / UPDATE

Work Order update only



Work Order: 180720					
Part No. D5957					
NCR No. 19-7189					
Date: 18/07/02		Step #: 100			
Description Work Order Deviation					
slot is under tolerance, it must be between 0,313 and 0,308. measure on the piece is: 0,297.					
DISPOSITION		AGAINST DEPARTMENT/PROCESS			
Suspected Unapproved		Water Jet Prod. Eng. Coord. Rec./Store/Packaging Supplier			
Rework Scrap		Engineering Quality Other			
Use-as-is					
Skid-tube Machining Large Fab		Cross tube Small Fab Finishing Composite			
Thermoforming					
QTY Effective : 1		MRB (QS1042) Approval D 18-07-16			
Disposition					
scrap and destroyed. replace 1 with Billet: SAC9074					
Completed By Vincent Hubert-D... Lead hand / Supervisor Approval Verification smk 18/07/12					
QC / QA Coordinator Approval D 18-07-16					
Root Cause					
Environment Design Doc/Data Equip/Tooling Handling/Pre Material Internal Transport Tribal Knowledge LOA Substation Past Expiry Date Misidentified					
No Re-verification Operator Offset/Setup Supplier Training Use for Testing Poor Information Rushing Product Improvement Process Improvement Manufacturing Process Past Due					
Pressure/Forced Bending Centre Not Concentric Cracks Crimp/Kink/Ripple/Wave Cuffs Crushing Heat Treat Wave/Twist in Tube Marks/Chatter					
Temperature/Cure Set-up BOM/Route Broken/Damage/Defect Inspection Incomplete/Unqualified Contamination Countersink Cut Too Short Instructions Incomplete/Unclear Drill Holes					
Power Loss/Surge Folio/Program Grain Weld Wrong Stock Pulled Out of Sequence Off-set Mislabeled Fit/Function Misaligned/off center					
Positioned Wrong Outside Dimensions Over/Under tolerance Part Incorrect Part Lost/Missing Part Moved Drawing Finish Misread Turning Sequence					
OTHER :					

H:/FORMS/Quality Assurance/approved QA/NCRWO Rev I